



Dart Aerospace Ltd.
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647.7326

Job Sheet 216148



Part No: 647.7326

Job Qty: 1 pcs

Part Name: EC135 T2/P2 Upper Cutter Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 12/18/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.7300 rev.G IPP REV:A NEW ISSUE JLM 16-12-16 VERIFIED BY:DD IPP REV:B 20.07.06 AS PER
DWG REV.F DD VERF;JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	DAS Sign-off
110	Packaging 1 - Pick Kit	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 1 - SCH-S	(1-3)	80 9-89
120	QC 4	1 pcs	12/18/20	12/18/20	0.00	0.00	QC 4 - 28		DEC 07 2020
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
							QC 4 - 72		DEC 08 2020
							QC 4 - 74		DAS 69
							QC 4 - 75		9-89
							QC 4 - 78		
							QC 4 - 84		
							QC 4 - 80		
							QC 4 - 85		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		DAS 69
							Packaging 3 - 4 - B4B		9-89
							Packaging 3 - 5 - B4B		DEC 08 2020
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		



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Container No: S318856



Part: 647.7326

Job No: 216148

Serial No/Batch: S318856

Revision: REV.G

Inspector:

Exp Date:

Instructions: URF17-611 FAA STC SP02307A 16/11/29, T

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				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
135 DC - 1 - B4B	1 pcs	12/18/20	0.00 0.00	DC - 1 - B4B	DAS 69 DEC 08 2020
				DC - 2 - B4B	9-89
140 QC 21 - SA	1 pcs	12/18/20	0.00 0.00	QC 21 - SA - 21	DAS 21 DEC 08 2020
				QC 21 - SA - 70	9-89
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 647.7326

135 - Document Control - Photocopy bluefile & type labels per PPP 647.7326

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	N/A
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	N/A
600.1012	Sealant PR1425B2 (#654 sem) 07/21/2021	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.1404	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.5710	GPS Mount	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7701	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
AN3-11A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN44-12A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L3	Nut	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L5	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-27	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0332P	Washer (AN960-10L)	19 Ea (19 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0532P	Washer (AN960-516L)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	13	0
	601.2045	1	22	0
	647.0112	2	10	0
	647.1404	1	7	0
	647.5710	1	14	0
	647.7701	2	17	0
	AN3-11A	2	146	0
	AN316C4R	2	46	0
	AN44-12A	2	4	0
	AN4C7A	2	56	0
	AN665-34R	2	28	0
	MS21042L08	2	1,870	0
	MS21042L3	7	1,464	0
	MS21042L4	2	1,215	0
	MS21042L5	2	310	0
	MS27039-08-13	2	186	0
	MS27039-1-27	5	78	0
	NAS1149F0332P	19	1,399	0
	NAS1149F0432P	4	1,041	0
	NAS1149F0532P	2	1,356	0
	NAS1149FN832P	4	2,133	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				

Job Fabrication

Job No: 216148

Part No: 647.7326

Sort by: ☐ Location ☒ Component

Operation	Required	Component	Description	BOM Quantity	Quantity Required	Quantity Available	Location	Container No	Serial No/Batch	Quantity Picked
110-Packaging 1 - Pick Kit	1	600.1012 <i>Exp Date 07-21-2021</i>	Sealant PR1425B2 (#654 sem)	1.0000	1.0000	8.0000	CCK017	S312691	S312691	1
110-Packaging 1 - Pick Kit	1	601.2045 <i>Exp Date 08-20-2022</i>	RTV (LOCTITE 598)	1.0000	1.0000	3.0000	Small Fab - 1	S299615	S299615	0
						4.0000	CCK095C	S304317	S304317	1
						10.0000	CCK095C	S312295	S312295	0
110-Packaging 1 - Pick Kit	1	647.0112	Strut Bracket	2.0000	2.0000	8.0000	CCK106	S303073	S303073	2
110-Packaging 1 - Pick Kit	1	647.1404	Upper Cutter Assembly	1.0000	1.0000	2.0000	CCK048	S229107	S229107	0
						1.0000	CCK048	S245514	S245514	0
						4.0000	CCK048	S290536	S290536	1
110-Packaging 1 - Pick Kit	1	647.5710	GPS Mount	1.0000	1.0000	1.0000	CCK083	S242991	S242991	0
						3.0000	CCK083	S301569	S301569	0
						8.0000	CCK083	S306497	S306497	0
						2.0000	CCK083	S306610	S306610	1
110-Packaging 1 - Pick Kit	1	647.7701	Strut Assembly	2.0000	2.0000	2.0000	CCK114	S239607	S239607	0
						3.0000	CCK114	S258872	S258872	2
						12.0000	CCK114	S280106	S280106	0
110-Packaging 1 - Pick Kit	1	AN3-11A	Bolt	2.0000	2.0000	20.0000	ST349	S304745	S304745	2
						100.0000	ST338F	S310893	S310893	0
110-Packaging 1 - Pick Kit	1	AN316C4R	Nut, Jam	2.0000	2.0000	44.0000	ST331	S312624	S312624	2
110-Packaging 1 - Pick Kit	1	AN44-12A	Eyebolt	2.0000	2.0000	4.0000	ST339	S095257	S092257	2
110-Packaging 1 - Pick Kit	1	AN4C7A	Bolt	2.0000	2.0000	54.0000	ST345	S235182	S235182	2
110-Packaging 1 - Pick Kit	1	AN665-34R	Clevis	2.0000	2.0000	4.0000	ST330	S235821	S235821	0
						2.0000	ST330	S311655	S311655	2
						10.0000	ST330	S316428	S316428	0
110-Packaging 1 - Pick Kit	1	MS21042L08	Nut	2.0000	2.0000	1,686.0000	ST303	S307361	S307361	2
110-Packaging 1 - Pick Kit	1	MS21042L3	Nut	7.0000	7.0000	151.0000	FP001	S304836	S304836	0
						2.0000	Crosstubes - 4 - B4B	S308481	S285188	0
						112.0000	ST303	S309678	S309678	

										7
						800.0000	ST299F	S314382	S314382	0
						2.0000	ST303	S318589	S204283	0
110- Packaging 1 - Pick Kit	1	MS21042L4	Nut	2.0000	2.0000	11.0000	GA011	S228833	S228833	0
						66.0000	FP001	S278891	S278891	0
						784.0000	ST303	S282343	S282343	0
						6.0000	ST303	S317797	S282343	2
						200.0000	ST299F	S318124	S318124	0
						8.0000	ST303	S318590	S157064	0
110- Packaging 1 - Pick Kit	1	MS21042L5	Nut	2.0000	2.0000	37.0000	FP001	S283904	S283904	0
						1.0000	ST303	S302482	S302482	0
						50.0000	ST299F	S307427	S307427	0
						100.0000	ST299F	S312901	S312901	0
						98.0000	ST303	S316411	S316411	0
						200.0000	ST299F	S318125	S318125	0
						2.0000	ST303	S318591	S203290	2
110- Packaging 1 - Pick Kit	1	MS27039-08-13	Screw	2.0000	2.0000	26.0000	ST278	S123937	S123937	0
						58.0000	ST278	S306830	S306830	2
						100.0000	ST278	S314058	S314058	0
110- Packaging 1 - Pick Kit	1	MS27039-1-27	Screw	5.0000	5.0000	23.0000	ST279	F110606	110606	0
						55.0000	ST279	S297583	S297583	5
110- Packaging 1 - Pick Kit	1	NAS1149F0332P	Washer (AN960-10L)	19.0000	19.0000	2.0000	GA200	S103666-1	S103666	0
						282.0000	FP001	S216387	S216387	0
						526.0000	ST263	S309801	S309801	19
						1,000.0000	ST260A	S318170	S318170	0
110- Packaging 1 - Pick Kit	1	NAS1149F0432P	Washer (AN960-416L)	4.0000	4.0000	160.0000	FP001	S247872	S247872	0
						6.0000	GA200	S247872-1	S247872	0
						3.0000	ST262	S309699	S309699	3
						750.0000	ST262	S316414	S316414	1
						12.0000	ST262	S317800	S309699	0
110- Packaging 1 - Pick Kit	1	NAS1149F0532P	Washer (AN960-516L)	2.0000	2.0000	600.0000	ST260A	FM133725	M133725	0
						742.0000	ST262	F18057-4	18057	2
						14.0000	GA200	f18057-4-1	18057	0
110- Packaging 1 - Pick Kit	1	NAS1149FN832P	Washer (AN960-8)	4.0000	4.0000	165.0000	FP001	S136368	S136368	0
						32.0000	ST260A	S293710	S293710	0
						576.0000	ST260A	S310426	S310426	0
						976.0000	ST263	S316423	S316423	4